

Date: Tuesday, 07/04/2009 10:34:59 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 47017	
Estimate Number : 12942	
P.O. Number :	Part Number : D3594044
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3594 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 46719	Material :
Written By :	Due Date : 15/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.04.07</u>	
Comment : Est Rev :A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)

6061-T6 .080 Sheet

Batch: 111003

M 09.04.08 (10)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

M 09.04.08 (10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 09.04.08

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/04/08 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

09/04/08 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:34:59 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 47017

Part Number: D3594044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



(-4)

Comment: INSPECT WORK TO CURRENT STEP

509/04/14

(+10)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML

09-04-14

(x10)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/14

9.0	MS210695	Anchor nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Anchor nuts

BATCH: M111310

09/04/15

10.0	MS20426AD44	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

BATCH: M15541

09/04/15

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

09/04/15 (10)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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(-4)

Comment: INSPECT WORK TO CURRENT STEP

502/04/15 (x10)

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 234B

09/04/15 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:34:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 47017

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/15 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MUF 09-04-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4700
Description: Floor Doubler, RH		Part Number: D3594-4
Inspection Dwg: D3594	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

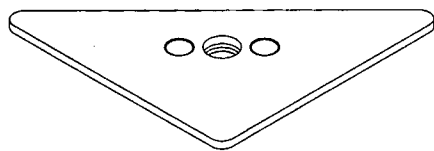
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.25	+/-0.030	12.25	✓		M.T	
7.85	+/-0.030	7.85	✓		VERN	
7.313	+/-0.010	7.313	✓		VERN	
2.688	+/-0.010	2.691	✓		VERN	
Ø0.323	+0.006/-0.001	0.325	✓		VERN	
Ø0.129	+0.005/-0.001	0.129	✓		VERN	
0.359	+/-0.010	0.360	✓		VERN	
0.718	+/-0.010	0.723	✓		VERN	
0.81	+/-0.030	0.815	✓		VERN	
2.35 2.32	+/-0.030	2.32	✓		VERN	

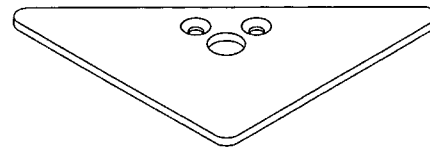
Measured by: M.M	Audited by: S	Prototype Approval:	N/A
Date: 09.04.08	Date: 09/04/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-044	KJ/JLM	BE

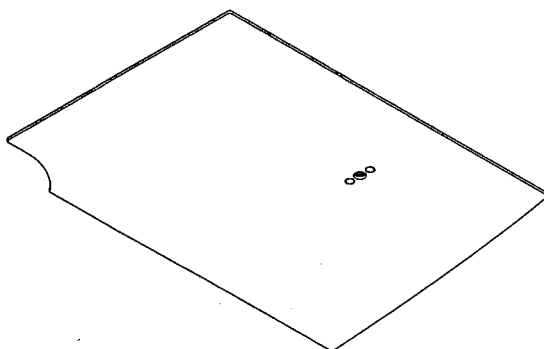
65 162



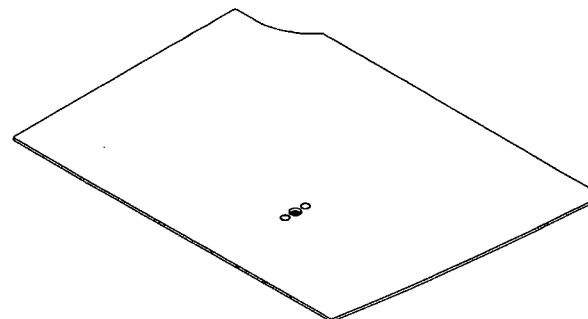
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



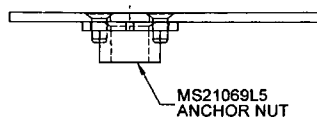
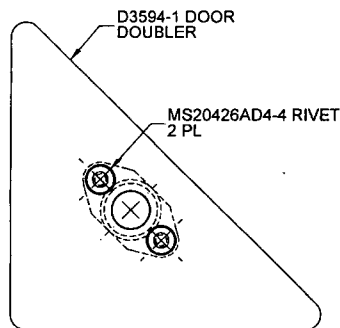
D3594-044 FLOOR DOUBLER ASSEMBLY

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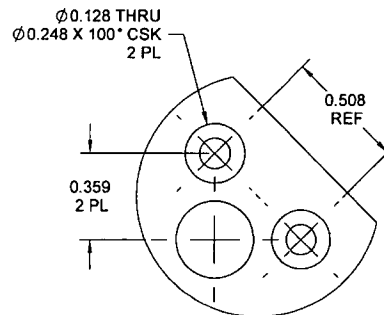
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WORK ORDER
NO. 4781

B	REFORMAT TO B SIZE DRAWING, SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3594		REV. B	
TITLE DOUBLER		SCALE	
		NTS	
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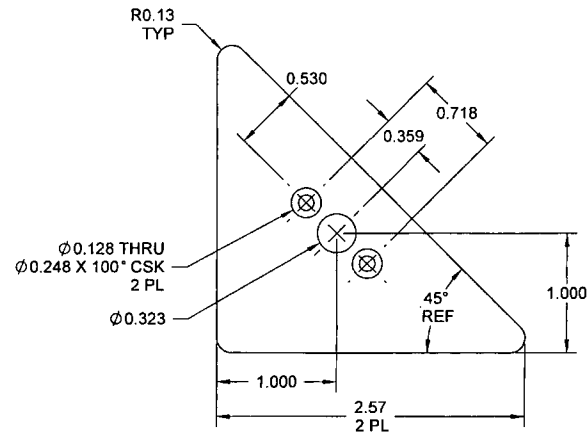
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



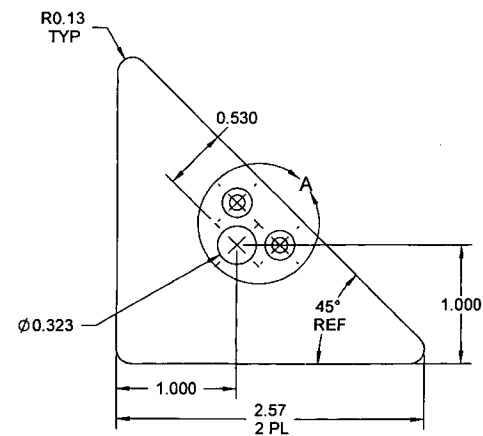
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER B

NOTES:

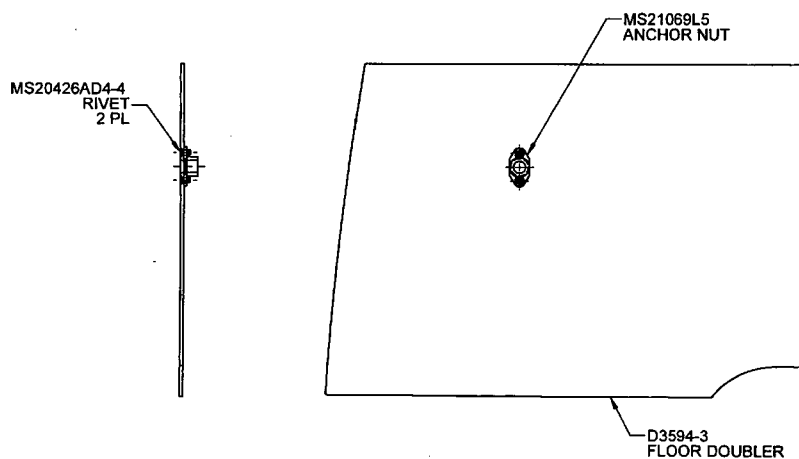
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

WEIGHT: 0.04 lbs
0.03 lbs
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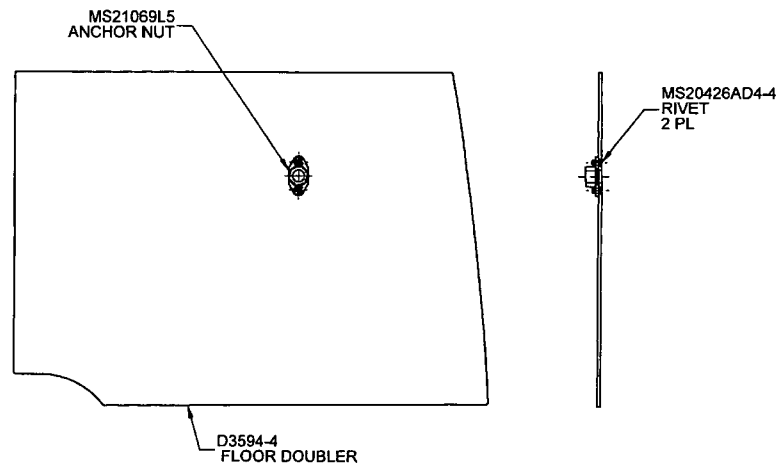
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08-05-26 1/14

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

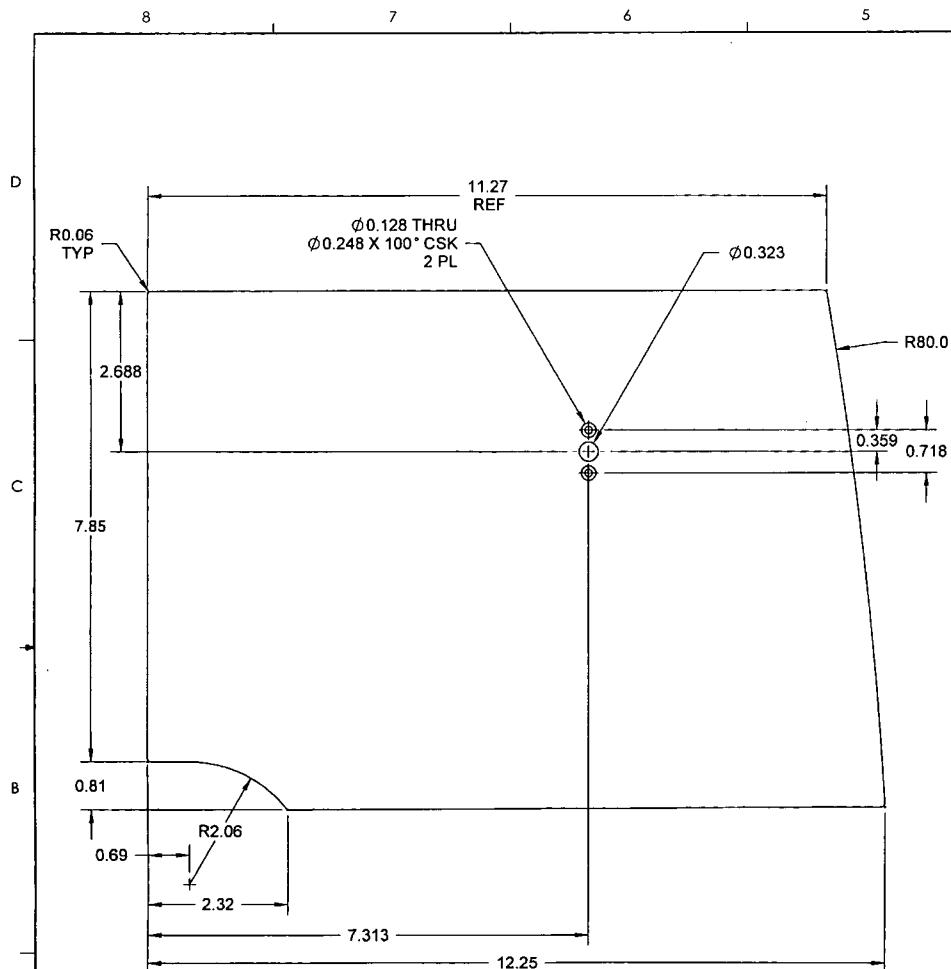
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
WEIGHT -043 & -044: 0.80 lbs

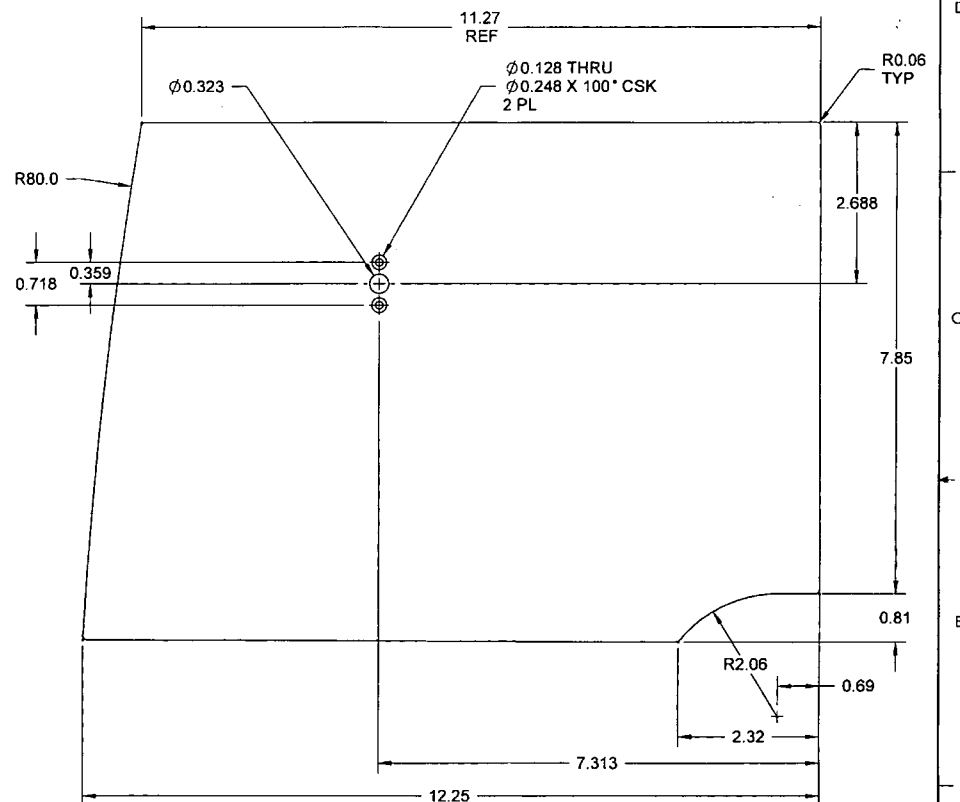
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

RELEASED
08.05.14

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CHECKED	<i>[Signature]</i>	DRAWING NO. D3594	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE DOOR DOUBLER ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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